

Date: Thursday, 10/18/2007 7:46:51 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LH ACTUATOR ASSEMBLY
Job Number	: 35181		
Estimate Number	: 12761		
P.O. Number	: <u>N/A</u>	Part Number	: 41232 200 001 001
This Issue	: 10/18/2007 S.O. No. : <u>N/A</u>	Drawing Number	: 41232-200-001 REV IR
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision	: IR
Previous Run	: 31450	Material	: <u>N/A</u>
Written By	: <u>[Signature]</u>	Due Date	: 10/24/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>[Signature] 07.10.18</u>		
Comment	: Est Rev: A New Issue 07-02-28 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MS208224	elbow
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

elbow

Batch: M104427

2.0	AN8424D	Elbow
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Elbow

Batch: M104156

3.0	41232 200 007 001	Brass Cylinder Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Brass Cylinder Assembly

Batch: B30942

4.0	MS1699623	cap screw
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

cap screw

Batch: M103937

5.0	AN3154R	Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Nut

Batch: M17566

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M105906

*Handwritten signature*

7.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M105792

*Handwritten signature*

8.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Nut

Batch: M105588

*Handwritten signature*

9.0

AN322A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M3413

*Handwritten signature*

10.0

41232 200 005 003

Spacer (Step Actuator)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer (Step Actuator)

Batch: 31022

*Handwritten signature*

11.0

41232 200 002 005

pivot arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pivot arm

Batch: B31778

*Handwritten signature*

12.0

41232 200 002 003

latch



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

latch

Batch: B31777 B35203

*Handwritten signature* 7/12/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: DD Date: 08/01/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Part Number: 41232 200 001 001

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

41232 200 002 001

tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

tube

Batch: B31774W

14.0

41232 200 008 001

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Decal

Batch: ATO B31023W

15.0

S 1455

spring-step actuator (replaces 71459)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

spring-step actuator (replaces 71459)

BATCH: 71240757/12/04 (1)

16.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg 41232-200-001

2-Torque as per Dwg 41232-200-001

X1

ml 08/01/16

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/16 (XL)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP 35059AS 08/01/17 (XU)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/17 (1)

Job Completion

W 08/01/17

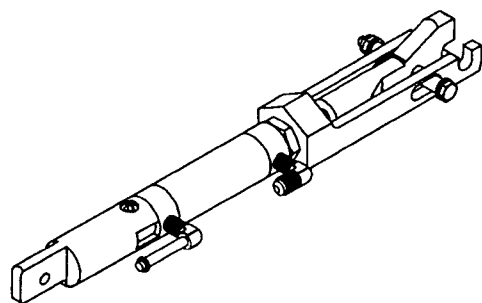
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

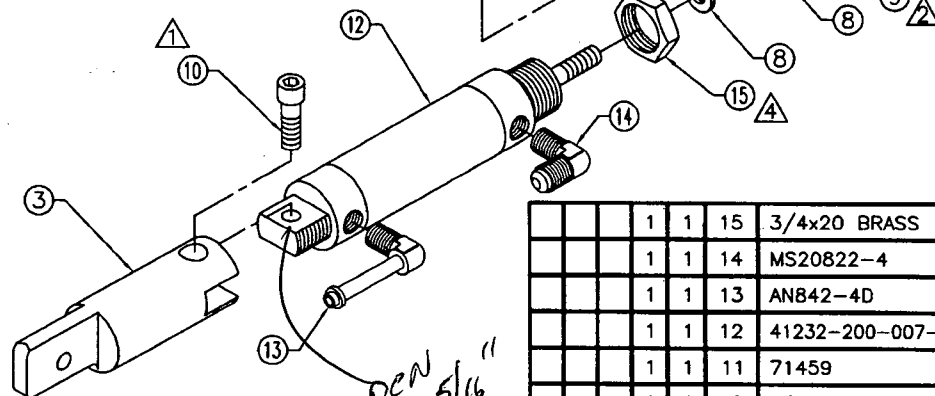
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



-001 L/H ACTUATOR ASSY



INSTALL ITEM #12  
ON OPPOSITE SIDE

-002 R/H ACTUATOR ASSY

- NOTES:
- ▲ TORQUE 80-100 IN.-LB.
  - ▲ TORQUE 20-25 IN.-LB.
  - ▲ TORQUE 50-75 IN.-LB.
  - ▲ TORQUE 50-75 IN.-LB.

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 35781

		1	1	15	3/4x20 BRASS	CYLINDER NUT						
		1	1	14	MS20822-4	ELBOW						
		1	1	13	AN842-4D	ELBOW						
		1	1	12	41232-200-007-001	CYLINDER						
		1	1	11	71459	SPRING						
		1	1	10	MS16996-23	CAP SCREW						
		1	1	9	AN315-4R	NUT						
		2	2	8	AN960JD416	WASHER						
		2	2	7	AN960JD10	WASHER						
		1	1	6	MS21042-L3	NUT						
		1	1	5	AN3-22A	BOLT						
		2	2	4	41232-200-005-003	SPACER						
		1	1	3	41232-200-002-005	PIVOT ARM						
		1	1	2	41232-200-002-003	LATCH						
		1	1	1	41232-200-002-001	TUBE						
					-002	R/H ACTUATOR ASSY						
					-001	L/H ACTUATOR ASSY						
					-002-001	END NO.						
					PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE		

NO. REQ'D PER ASSY				LIST OF MATERIAL			
PROPRIETARY RIGHTS NOTICE				UNLESS OTHERWISE SPECIFIED X±.1			
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				CHECK D. MURPHY 5/20/02			
				STRESS			
				PROJ. ENGR.			
				HEAT TREAT			
				FINISH			
-002-001 1 41232-000-001				DWC. SIZE C SCALE NONE			
NEXT ASSEMBLY				DWC. NO. 41232-200-001			
				REV. IR			

Era Aviation, Inc.